

Need for Tues. 07/02
SANS PARTS

Dart Aerospace Ltd.

Date: Friday, 2/23/2007 8:31:21 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 30877		
Estimate Number	: 10260		
P.O. Number	: N/A	Part Number	: D23623
This Issue	: 2/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2362 REV E1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29775	Drawing Revision	: E1
Written By	: <u>[Signature]</u>	Material	: N/A
Checked & Approved By	: <u>[Signature]</u>	Due Date	: 2/28/2007
Comment	: Est: G 06.05.18 Added inspection level 8 EC	Qty:	10
		Um:	8
		Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Step Support
Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	829807

ml 07/02/23 10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

ml 07/02/23 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

ml 07/02/23 10

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8.7 07/02/23 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

ml 07/02/23 10

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

Q.M 07/02/24 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 30877

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : (~~8~~ 10000 Each(s) 10)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B29809 x9 ✓

B30971 x1

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : (~~8~~ 10000 Each(s) 10)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B29810 x9 ✓

B30972 x1

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M102565

m101/02/26 x10

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/27

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C7/4/28 (10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

19 07/02/28

Job Completion



4 07.02.28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	<i>CP</i>		
CHECKED <i>KE</i>	APPROVED <i>CP</i>	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 *CP*

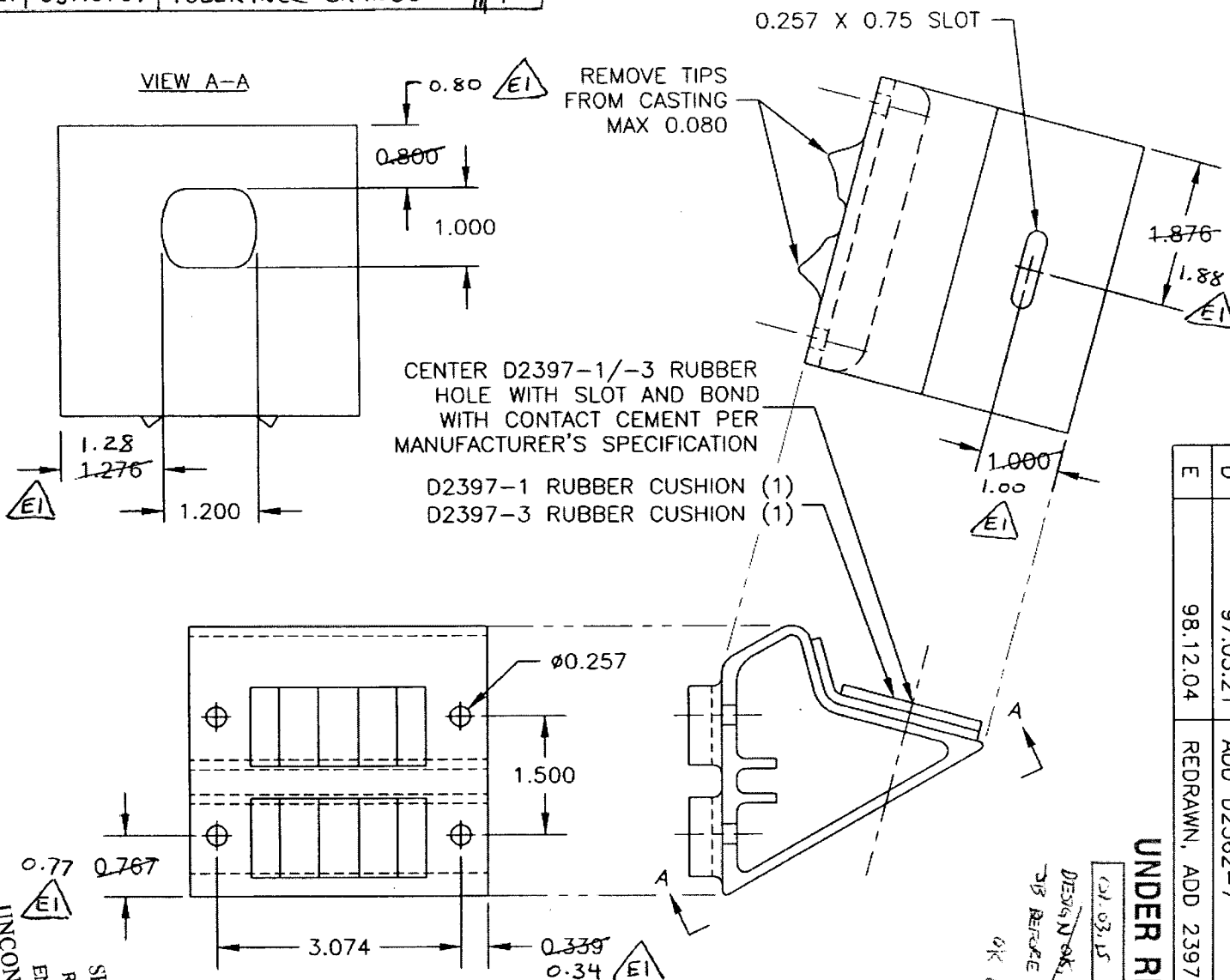
DESIGN OK, BUT CHECK WITH
3D BEFORE MANUFACTURE
OK 01/04/04

REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

D2362-3



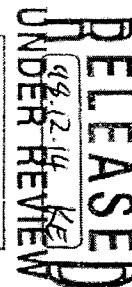
NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 30877
WORK ORDER
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CHECKED	APPROVED	DRAWING NO.	REV. E
KE	PH	D2362	SHEET 2 OF 3
DATE		TITLE	SCALE
98.12.04		STEP SUPPORT BRACKET	1:2



MESSENGER, BUT CHECK WY
JTS BIEBER, MANU FACTURE

OK
Feb 1.05

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 30877



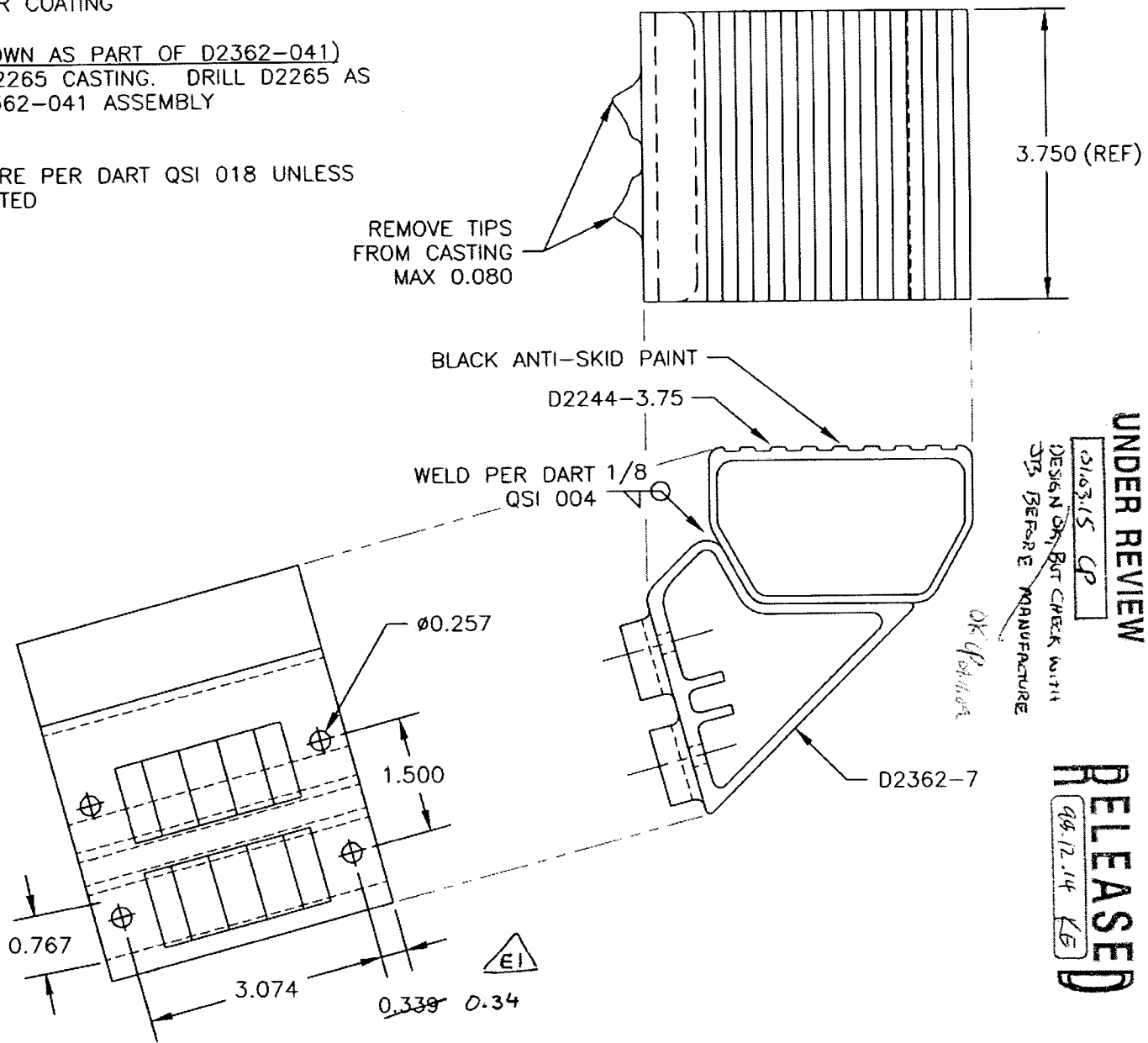
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BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	REV. E
DATE 98.12.04	DRAWING NO. D2362	SHEET 3 OF 3
	TITLE STEP SUPPORT BRACKET	SCALE 1:2

UNDER REVIEW

01.03.15 CP

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE



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